

Work Order ID 111868

Thursday, January 23, 2014 4:12:36 PM

111868

Page 1

Item ID: D4634-045 Accept ***N1900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft, Center Ceiling Panel Assembly
 Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: RP Date: 14-01-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	E								
100		0.00							
1100									
Hand Thermo	Memo	0.00							① SAO 14/01/28
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
1110									
Small Fab	Memo	0.00							① SAO 14/01/28
Small Fab	1- Assemble as per Dwg D4634-045								
	2- install No Smoking & seat belt symbols								
	3- Install led lights								
	4- Install Air valves								
	5-Install Wiring Harness								
	5-Install wiring harness								

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Page 2

Item ID: D4634-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Panel Assembly
Start Date: 1/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/29/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 141129				1			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>249</u> Memo	0.00 0.00					W		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MCS 1401-29	141401-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

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Page 1

Work Order ID: 111868

111868

Parent Item: D4634-045

D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc release DL VERIFIED BY:JLM
Update 13/07/09 DL verf: DD
13/12/23 DL
IPP Rev B
IPP Rev C Dwg
IPP Rev D Dwg Update
IPP REV E Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2351-20-27-C3C *2351-20-27-C3C* STUD		Purchased	No			100	Each	72.0000	1	1		14/01/28	
				<u>Location</u>				<u>Loc Qty</u>					
				ST396				72					
				m126740				30					
				m127922				42					
50-009-2 *50-009-2* Grommet		Purchased	No			100	Each	83.0000	1	1		14/01/28	
				<u>Location</u>				<u>Loc Qty</u>					
				ST378				83					
				122594				1					
				m128022				82					
D4634-145 *D4634-145* Aft, Center Ceiling Replacement Panel Assembly		Manufactured	No			100	Each	0.0000	1	1		14/01/28	
D4646-1 *D4646-1* Plenum Cap Assembly		Manufactured	No			100	Each	60.0000	2	2		14/01/28	
				<u>Location</u>				<u>Loc Qty</u>					
				ST116				60					
				103832				60					

Picklist Print

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Work Order ID: 111868

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Parent Item: D4634-045

D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 1/23/2014

Required Date: 1/29/2014

Start Qty: 1.00

Required Qty: 1.00

D4652-1 Manufactured No

100 Each 191.0000 2 2

D4652-1

Air Valve, 1.16 Id Disk Type

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST099

191

111311

191

B111111

2

D4728-049 Manufactured No

100 Each 0.0000 1 1

D4728-049

Advisory Light, Aft

**

SAD 14/01/28

D4728-055

Manufactured No

100 Each 1.0000 1 1

D4728-055

Cabin Lights #3

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST121

1

111208

1

8

PLT1.5M-M Purchased No

100 Each 945.0000 8 8

PI T1 5M-M

Tie Wrap

**

SAD 14/01/28

Location

Loc Qty

Loc Code

ST389

945

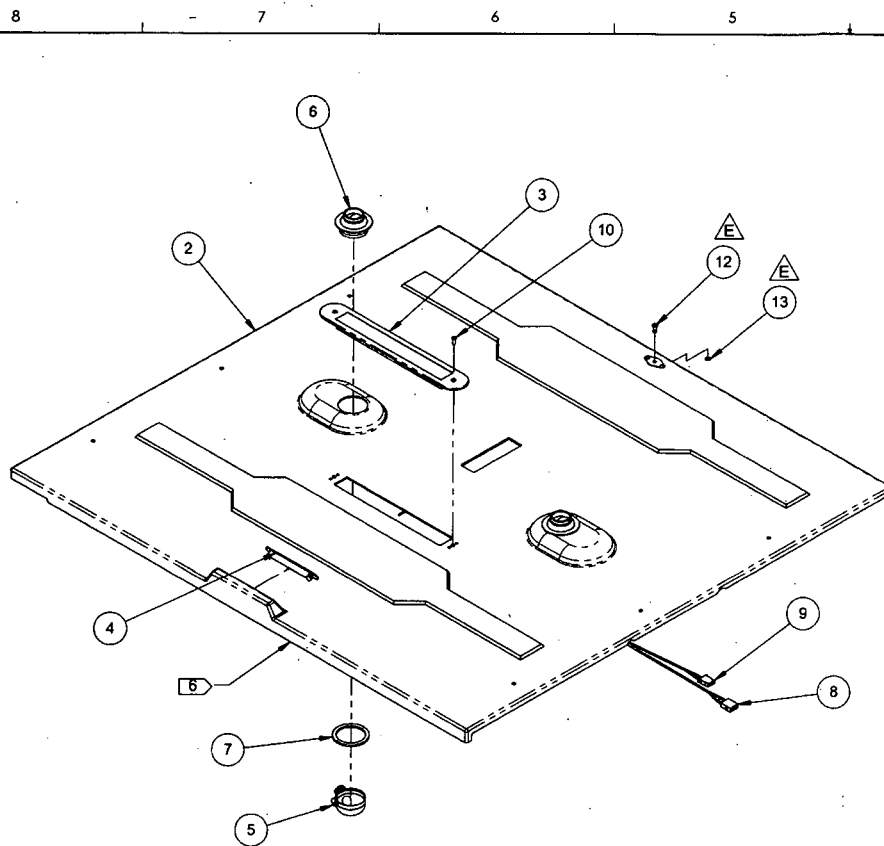
124363

2

m126551

943

8



ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (PART OF D4728-055)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-049)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
8	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
9	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4728-055)
11	10	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
12	1	2351-20-27-C3C	STUD
13	1	50-009-2	GROMMET

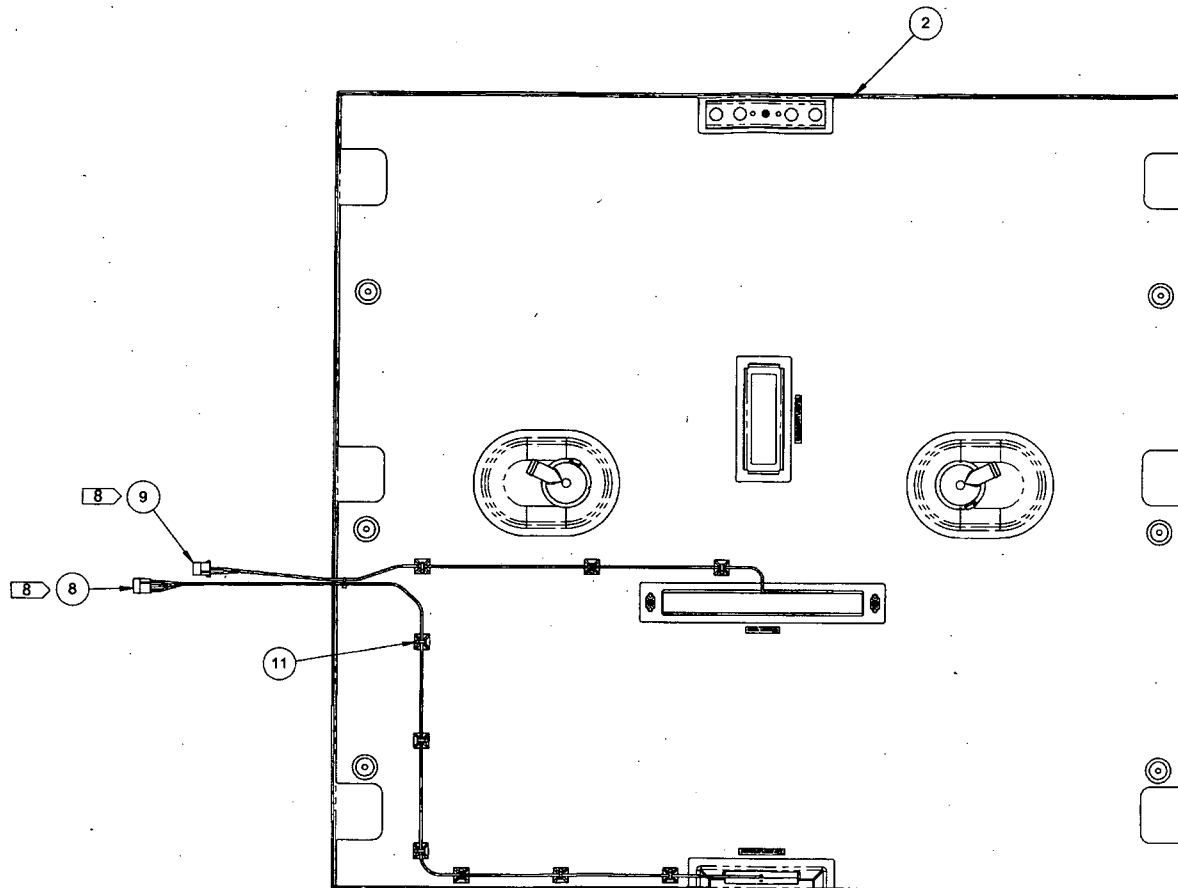
111868
R014-0123

D4634-045 AFT, CENTER CEILING PANEL ASSY

RELEASED
2014-01-22

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
 - 7) WEIGHT: 10.5 lbs
 - 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

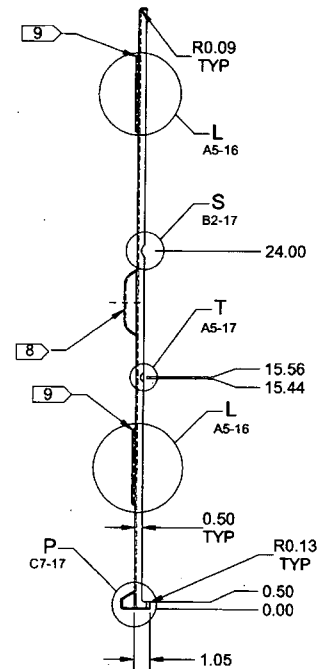
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DE APPR.	DC	NTS	
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D4634-045 AFT, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
2014-01-22
110

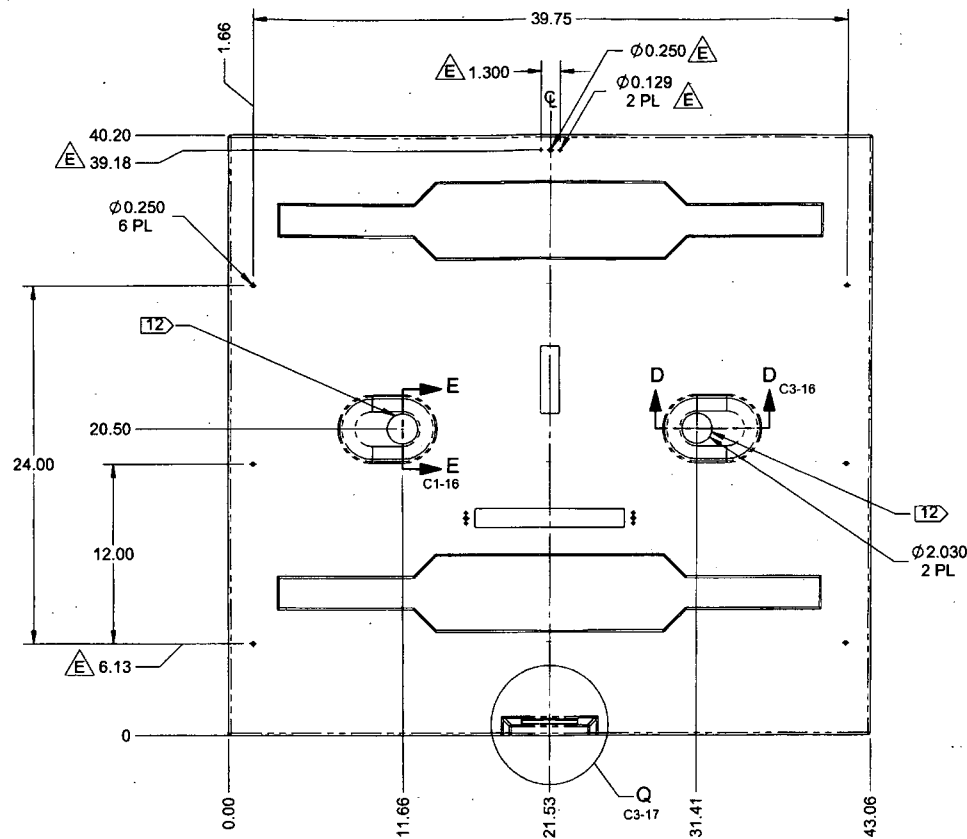
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2014-01-22

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.39 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-5 PER TOOL DT9838
- 11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
- 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

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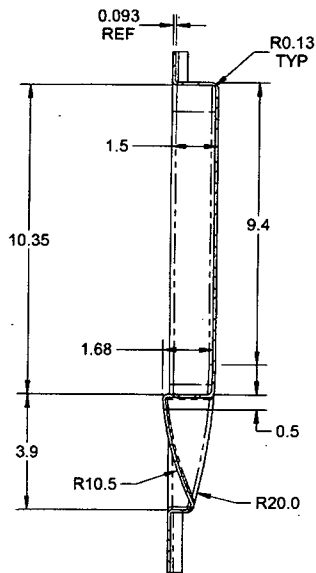


D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

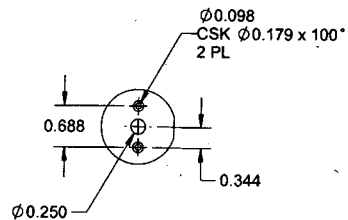
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2014-01-22

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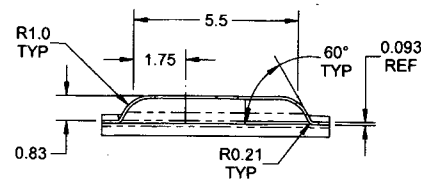
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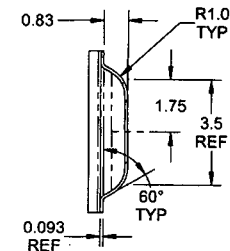
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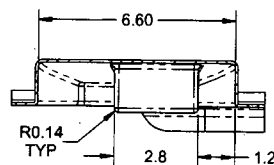
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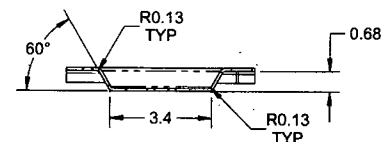
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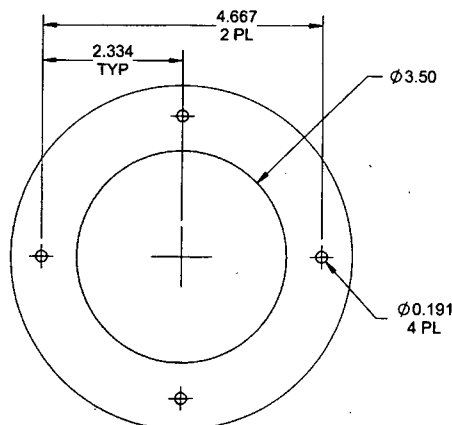
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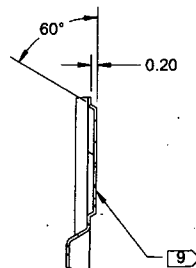
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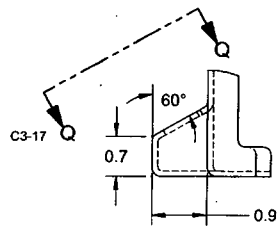


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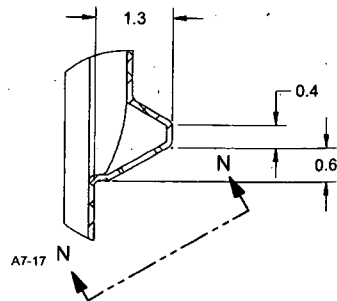
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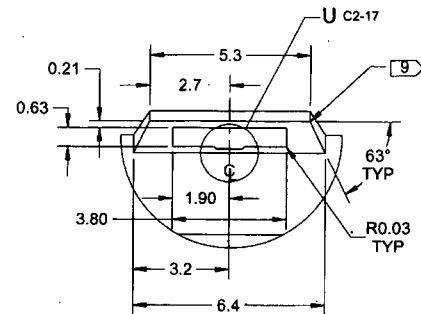
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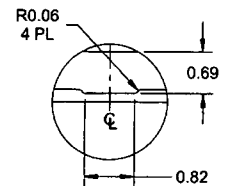
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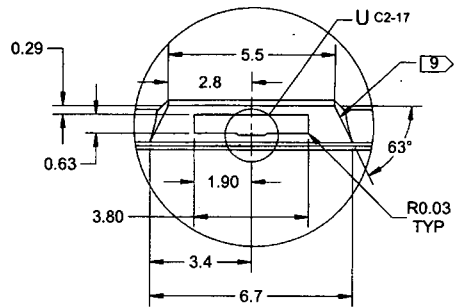
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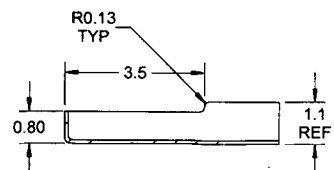
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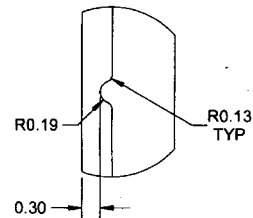
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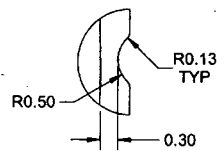
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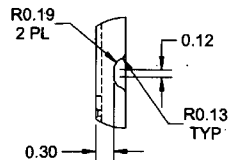
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SCALE 1.3X



DETAIL R B3-10
SCALE 4X



DETAIL S B3-10
SCALE 4X



DETAIL T C2-14
SCALE 4X

RELEASED
2014-01-22

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